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CLAIMS

1. A method of casting metal strip comprising:
holding a pair of chilled casting rolls in
parallel relationship so as to form a nip between them and
5 such that at least one of the rolls is moveable bodily and
laterally relative to the other roll,
continuously biasing said one roll laterally
toward the other roll,
setting an initial gap between the rolls at the
10 nip which is less than the thickness of the strip to be
cast,
rotating the rolls in mutually opposite
directions such that the peripheral surfaces of the rolls
travel downwardly at the nip between them,
15 pouring molten metal into the nip between the
rotating rolls so as to form a casting pool of molten metal
supported on the rolls above the nip and controlling the
speed of rotation of the rolls so as to establish casting
of a strip delivered downwardly from the nip which at the
20 outset of casting is produced to a thickness which is
greater than the initial gap between the rolls so that the
initially formed strip forces said one roll bodily away
from the other roll against the continuous bias to increase
the gap between the rolls to accommodate the thickness of
25 the initially cast strip, and
continuing casting to produce strip at said
thickness and with the gap between the rolls increased
beyond the initial gap.
2. A method as claimed in claim 1, wherein the
30 peripheral surfaces of the rolls are negatively crowned
when cold by being formed at their midparts to a radius
which is less than the radius of end parts of those
surfaces, the initial gap being set such that the end parts
of the peripheral surfaces of rolls are spaced apart by no
35 more than 1.5mm.
3. A method as claimed in claim 2, wherein the
spacing between the end parts of the rolls is in the range

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0.5 to 1.4mm.

4. A method as claimed in claim 2 or claim 3, wherein the radial negative crown for each roll is in the range 0.1 to 1.5mm.

5 5. A method as claimed in any one of the preceding claims, wherein said other roll is held against lateral bodily movement, said one roll is mounted on a pair of moveable roll carriers which allow said one roll to move bodily laterally of the other roll and said one roll is
10 continuously biased laterally toward the other roll by application of biasing forces to the moveable roll carriers.

6. A method as claimed in any one of the preceding claims, wherein the initial gap between the rolls is set by
15 positioning of a stop means to limit bodily movement of said one roll toward the other.

7. A method as claimed in claim 6, wherein the stop means is a stop which is set so as to be engaged by one or both of the moveable roll carriers.

Sub
A4

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